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D3646-3
Job Sheet 182587



Split from 17880

Part No: D3646-3

Job Qty: 6 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 6/26/18

Type: SOLD

Description:

Note: DWG REV C IPP Rev. A new issue 07.07.25 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		6/26/18	0.00	0.00	Start Up Small Fab-4		DAS
100	Brake NC	6 pcs		6/26/18	0.00	2.71	Brake NC 1		58 11/8/18
110	Small Fab	6 pcs		6/26/18	0.00	3.70	Small Fab-4		9-89
120	QC	6 pcs		6/26/18	0.00	0.00	QC5		
130	Powdercoat	6 pcs		6/26/18	0.00	0.20	Powdercoat4		
140	QC	6 pcs		6/26/18	0.00	0.00	QC3		
150	Packaging	6 pcs		6/26/18	0.00	0.00	Packaging3-1		
160	QC21-SA	6 Ea		6/26/18	0.00	0.00	QC21		Not Required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	17.4600 ft (2.91 ea)	90-Start up Operation	5084601

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.500W.035	17	287	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	26.500Inches ± 0.130	26.630 26.370		
2	Arm	2.500Inches ± 0.130	2.630 2.370		
3	Arm	5.750Inches ± 0.130	5.880 5.620		
4	Arm	15.000Degrees ± 0.500	15.500 14.500		
5	Arm	45.000Degrees ± 0.500	45.500 44.500		
6	Arm	30.000Degrees ± 0.500	30.500 29.500		

MD 19 Jun 2019

DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: <u>182587</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other			
Part No. <u>D3646-3</u>		☒ Rework ☐ Scrap ☐ Use-as-is		☐ Skid-tube Machining ☐ Thermofforming Large Fab		☐ Cross tube Small Fab ☐ Finishing Composite		☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier		☐ Engineering Quality Other	
NCR No. <u>19-7143</u>		Suspected Unapproved		QTY Effective: <u>6</u>							
Date: <u>AUG 29 2018</u>		Step #: <u>110</u>		Disposition							
Description Work Order Deviation											
<u>- PARTS NOT BENT TO DRAWING DIMENSIONS.</u>				<u>- SCRAP QTY 6.</u>							
<u>Need better work instruction</u>											
								Completed By <u>18.08.30</u> Lead hand / Supervisor <u>18.08.30</u> Approval Verification			
								QC / QA Coordinator <u>18.08.11</u> DAS Approval <u>9.18.05.10</u> 9-89			
Root Cause		FAULT CATEGORY									
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong	
Design		Operator		Bending		Set-up		Folio/Program		☒ Outside Dimensions	
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		☒ Over/Under tolerance	
☒ Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		☐ Part Incorrect	
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Ungualified		Wrong Stock Pulled		Part Lost/Missing	
Material		Use for Testing		Cuffs		Contamination		Out of Sequence		Drawing	
Internal Transport		Poor Information		Crushing		Heat Treat		Off-set		Part Moved	
Tribal Knowledge		Rushing		Wave/Twist in Tube		Cut Too Short		Misaligned		Finish	
LOA		Product Improvement		Marks/Chatter		Instructions Incomplete/Unclear		Fit/Function		Misread	
Substation		Process Improvement						Misaligned/off center		Turning Sequence	
Past Expiry Date		Manufacturing Process									
Misidentified		Past Due		OTHER :							